

Work Order ID 59506

Friday, June 04, 2010 3:02:22 PM



Page 1

Item ID: D4006-041

Accept



Setup

Start



Revision ID:

Item Name: Tank Top Support Assembly

Stop



Start Date: 6/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *PF*

Date: *10-6-04*

Tooling:

Date:

Run

Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4006	A

100



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4006

6/6/04/28 Q

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

6/6/04

(initials)

120



Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

Start Time: *9:15*
Oven Temperature: *320°*
Finish Time: *9:45*

① BL 10-7-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59506

Friday, June 04, 2010 3:02:22 PM



Page 2

Item ID: D4006-041

Accept



Setup

Start



Revision ID:

Item Name: Tank Top Support Assembly

Stop



Start Date: 6/4/2010 Start Qty: 1.00



Required Date: 6/10/2010 Req'd Qty: 1.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

Date: _____

Run

Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/

Work Center ID

130



QC

Quality Control

Operation

Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

0.00

Tool ID

1010707

Tool #

Plan

Code

Accept

Qty

Reject

Qty

Reject

Number

Insp.

Stamp

140



HandFinish

Hand Finishing

AR0.07.12

0.00

Memo 3m 1300 contact cement 0.00 Batch: 1113174

- 1- Apply glue and install Foam as per dwg
- 2- Install anchor nuts as per dwg

SD 10/07/14

C

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

SD 10/07/14

E

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Work Order ID 59506

Friday, June 04, 2010 3:02:22 PM



Page 3

Item ID:	D4006-041	Accept		Setup	Start		
Revision ID:							
Item Name:	Tank Top Support Assembly						
Start Date:	6/4/2010	Start Qty:	1.00		Stop		
Required Date:	6/10/2010	Req'd Qty:	1.00		Cust Item ID: Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging	Identify as per dwg & Stock Location: 110	0.00							<i>PC 10/7/14 C</i>
Packaging	Memo	0.00							
170 QC	QC21- Final Inspection - Work Order Release	0.00							<i>100715</i>
Quality Control	Memo	0.00							

MF 10-7-14

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 3:02:27 PM

Page 1 / 2

Work Order ID: 59506

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD
10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:E

Start Date: 6/4/2010

Required Date: 6/10/2010

Required Qty: 1.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ENG	4	
55660	4	
100	Each	1,921.000
		8

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ENG	2	
55659	2	

SR 07/7/13 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 3:02:28 PM

Page 2 /2

Work Order ID: 59506

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD
10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:B

Start Date: 6/4/2010

Start Qty: 1.00

Required Date: 6/10/2010

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-A RIVET						140	Each	6,712.000	4	4			

M7681 (4x)

Location	Loc Qty	Loc Code
ST316	6712	
104374	2712	
110398	4000	

MS21059L4



Nutplate

Purchased No

140 Each 53.0000

2 10/07/13 ①

Location	Loc Qty	Loc Code
ST301	30	
114718	30	
ST302	23	
112243	23	

2 10/07/13 ①

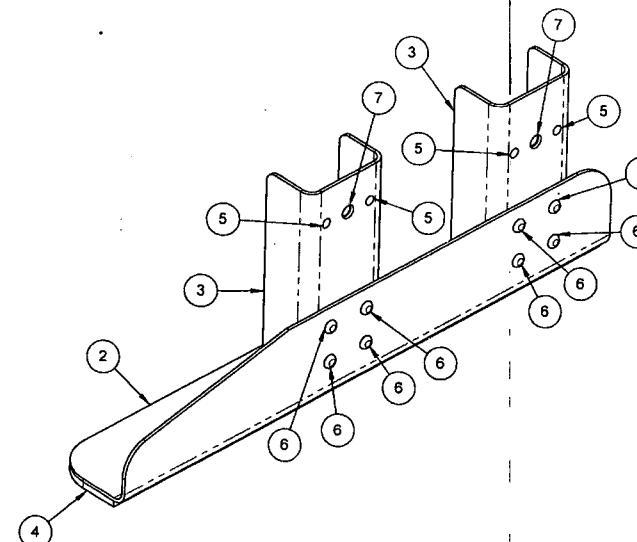
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3-4	RIVET	
6	8	MS20470AD4	RIVET	
7	2	MS21059-4	ANCHOR NUT	



D4006-041 TANK TOP SUPPORT ASSEMBLY

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4006-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59506
BS10-6-07

RELEASED
2010-05-05
MP

A	NEW ISSUE	10.02.05
REV.	DESCRIPTION	BY DATE
DESIGN	<i>AC</i>	
DRAWN	<i>AC</i>	
CHECKED	<i>BB</i>	
MFG. APPR.	<i>EC</i>	REV. A
APPROVED	<i>MP</i>	SHEET 1 OF 6
DE APPR.	<i>MP</i>	TITLE
DATE	10.02.05	SCALE
		NTS

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4006

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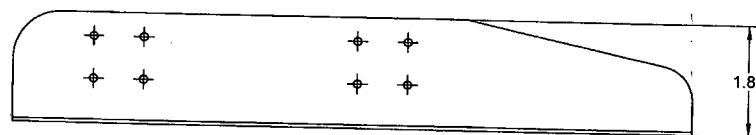
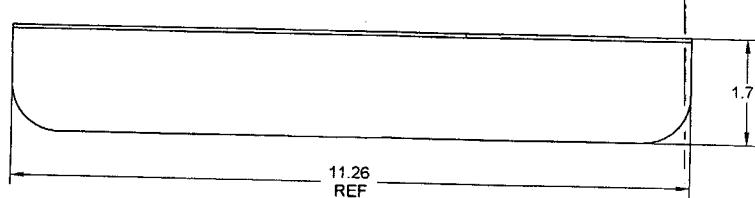
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	City	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector		
			Initial Chief Eng	Action Description Chief Eng	Sign & Date					

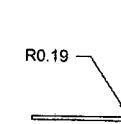
NOTE: Date & initial all entries

8	7	6	5	4	3	2	1
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER				REF JCA-M47-2-01		



D4006-1 ANGLE

WLR 59564



RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: MADE FROM D4006-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	<i>AE</i>	DART AEROSPACE LTD
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	REV. A
MFG. APPR.	<i>EE</i>	DRAWING NO.
APPROVED	<i>AB</i>	D4006
DE APPR.	<i>AB</i>	SHEET 2 OF 6
DATE	10.02.05	TITLE
		SCALE
		NTS

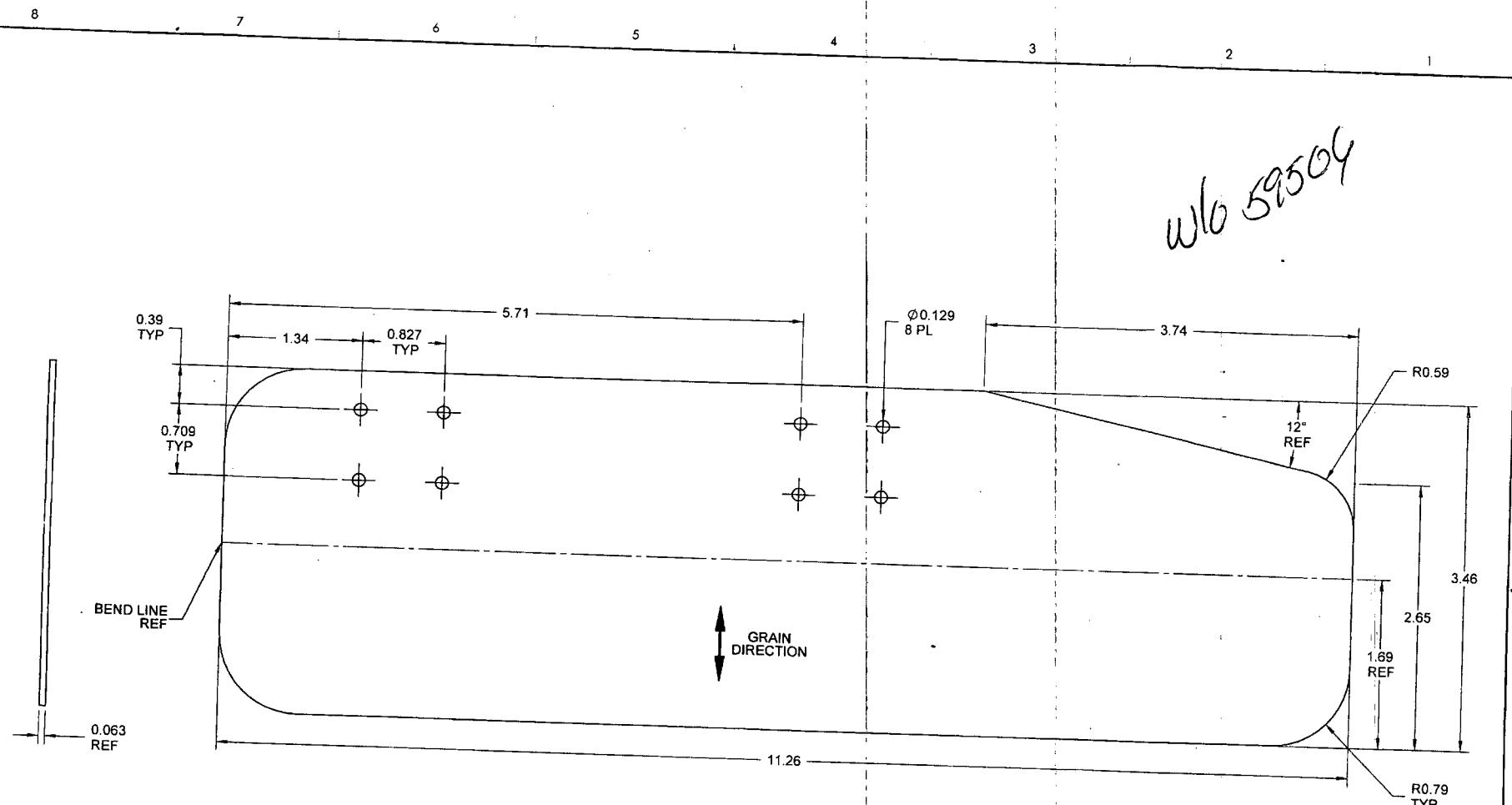
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4006-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>	DRAWING NO.
MFG. APPR.	<i>AS</i>	D4006
APPROVED	<i>AS</i>	REV. A
DE APPR.	<i>AS</i>	SHEET 3 OF 6
DATE	10.02.05	TITLE
		SCALE
		NTS
UPPER RESTRAINT		

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RELEASED
2010-05-05
AS

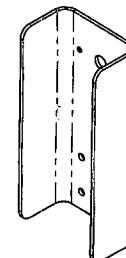
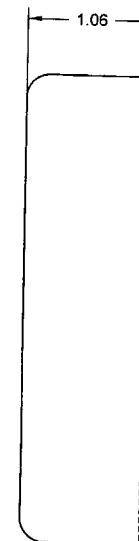
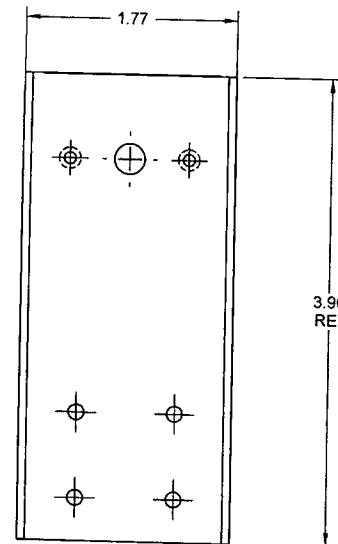
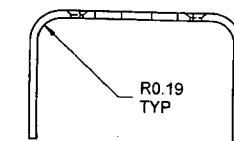
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8	7	6	5	4	3	2	1
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER						
D4006-3	REF JCA-M47-2-01						



W/6 5/5/04

D4006-3 CHANNEL

NOTES:

- 1) MATERIAL: MADE FROM D4006-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>RE</i>	DART AEROSPACE LTD	
DRAWN	<i>RE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RE</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RE</i>	D4006	SHEET 4 OF 6
APPROVED	<i>RE</i>	TITLE	
DE APPR.	<i>RE</i>	SCALE	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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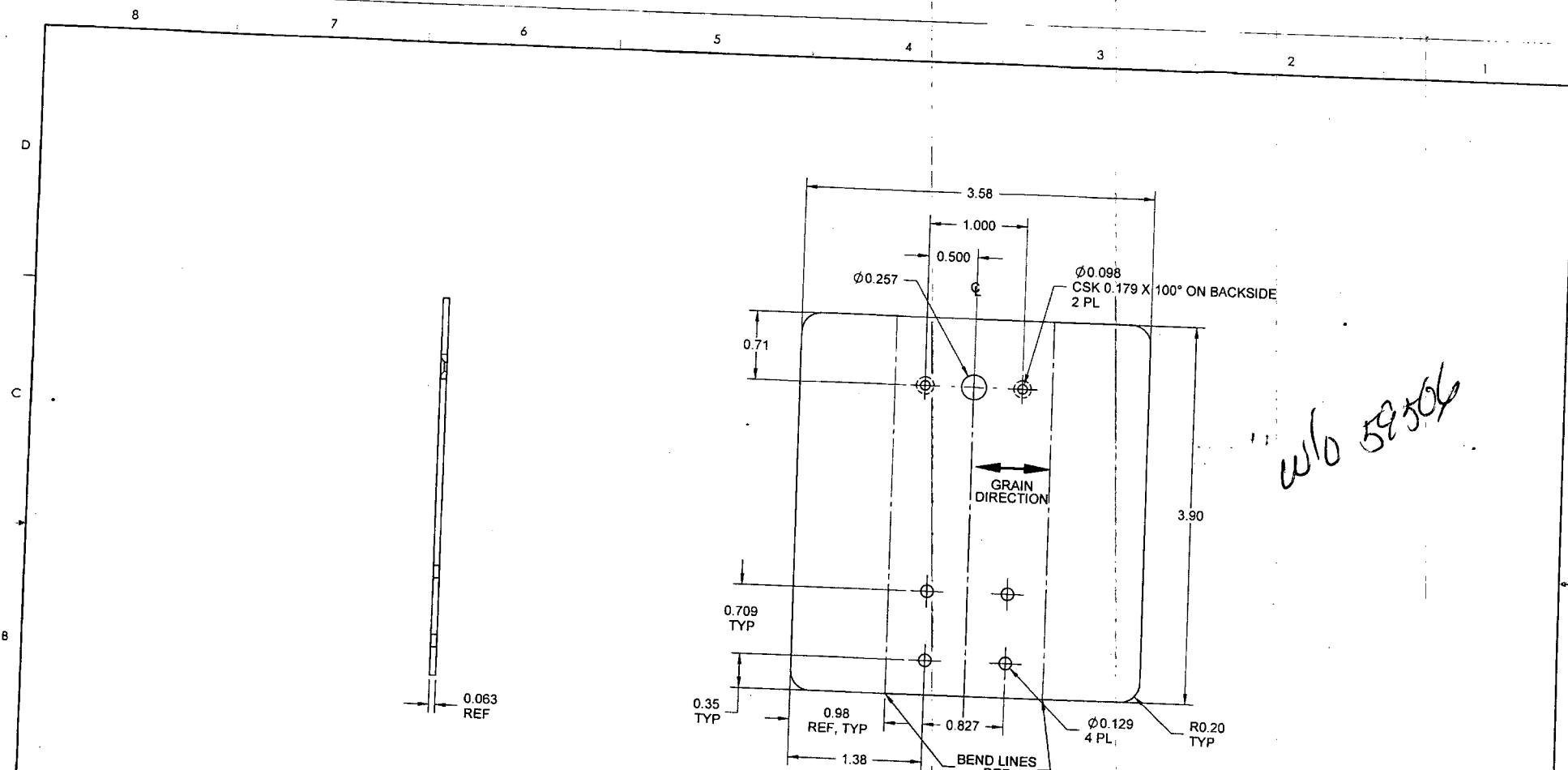
8 1 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4006-3F FLAT PATTERN

RELEASED
2010-05-05
MAD

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>BS</i>	DART AEROSPACE LTD
DRAWN	<i>BS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BS</i>	
MFG. APPR.	<i>BS</i>	DRAWING NO. D4006 REV. A
APPROVED	<i>BS</i>	SHEET 5 OF 6
DE APPR.	<i>BS</i>	TITLE
DATE	10.02.05	SCALE NTS

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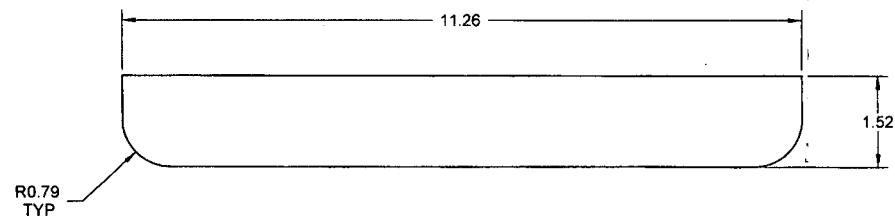
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NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-5	REF JCA-M47-2-01



D4006-5 FOAM

W/059504

0.13
REF

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
REF DART SPEC M-411N-S-125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>BB</i>	DART AEROSPACE LTD	
DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BB</i>	DRAWING NO.	
MFG. APPR.	<i>BB</i>	REV. A	
APPROVED	<i>BB</i>	D4006	
DE APPR.	<i>BB</i>	SHEET 6 OF 6	
DATE	10.02.05	TITLE	SCALE
		UPPER RESTRAINT	NTS

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

L Lacelle

From: Harvey Siemens [hsiemens@dartaero.com]

Sent: July 12, 2010 10:28 AM

To: 'L Lacelle'

Subject: RE: D4006-041

Good morning Linda,

Let's use the 3M 1300 contact cement to attach the foam.

Regards,

Harvey Siemens

Mechanical Designer

DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

E: hsiemens@dartaero.com

W: www.dartaero.com

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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From: L Lacelle [mailto:llacelle@dartaero.com]

Sent: Friday, July 09, 2010 6:37 AM

To: 'Harvey Siemens'

Subject: D4006-041

Hi Harvey,

The route calls to Apply glue and install foam. What kind of glue is req'd pls.?

Thank You,

Linda Lacelle

Production Manager

Dart Aerospace Ltd